

Date: Thursday, 16/11/2006 9:10:05 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW
Job Number	: 29454		
Estimate Number	: 10003		
P.O. Number	: N/A	Part Number	: D2214
This Issue	: 16/11/2006 S.O. No. : N/A	Drawing Number	: D2214 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 14/11/2006 Type : SMALL / MED FAB	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: <u>W</u>	Due Date	: 15/11/2006
Checked & Approved By	: <u>W</u>	Qty:	5 Um: Each
Comment	: Est Rev:C 99.04.29 Added New Jig and Part Numbers DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MACRLICS125	1/8" Polycast II Sheet
-----	-------------	------------------------



Comment: Qty.: 0.7960 sf(s)/Unit Total : 3.9800 sf(s)

1/8" Polycast Sheet

(M-acrylic-S.125)

BATCH:

m17626 x 7.1640
ml 06 11 16

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2214

Dwg Rev: E

Prog Rev: C

ml 06 11 16

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	D27281	Dart Logo label small
-----	--------	-----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2728-1

DART logo

B24215

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ID Date: 08/11/17
 QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/11/2006 9:10:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 29454

Part Number: D2214

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2462

Neoprene Seal



Comment: Qty.: 3.6700 f(s)/Unit Total : 18.3500 f(s)
Neoprene Seal

Pick:

Qty Part Number Description
44" D2462 SEAL

Batch

B22749

SB 06/11/14 ①

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2462 Seal to length and Install around edge

2-Transfer holes through seal

3-Attach small DART logo labels D2728-1as per template DT 8223

SB 06/12/16 ①

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.11.16 ①

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Wrap window in celophane wrap

SB 06/11/16 1

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Wrap in foam

Identify and Stock

Location: _____

06/11/17 ①

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/17 ①

Job Completion



06/11/17

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:

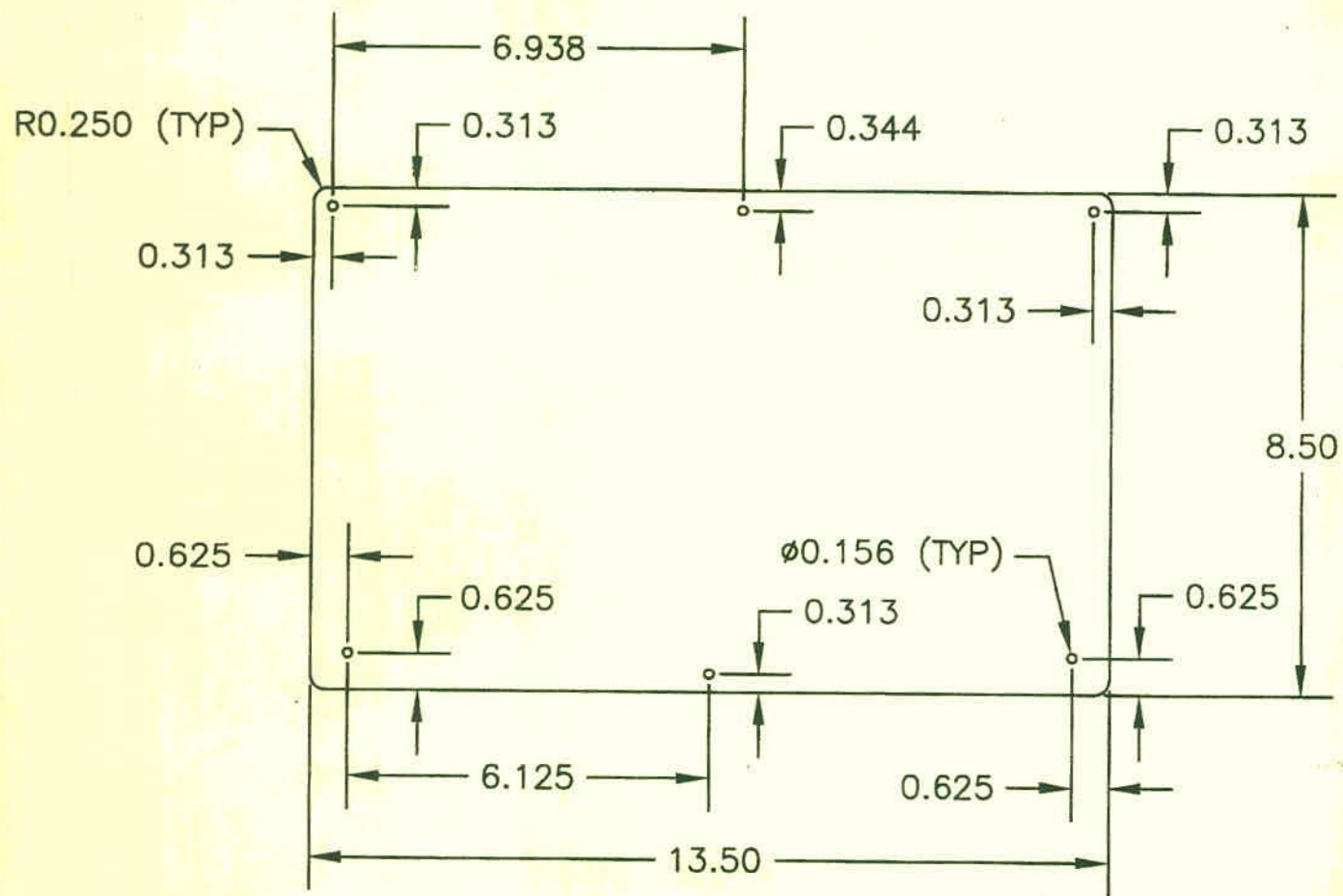
WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	BW	DRAWN BY	SSH	DART AEROSPACE LTD
CHECKED		APPROVED		HAMMERSBURY, ONTARIO, CANADA
DATE	06.04.13	TITLE	D2214	REV/C
			WINDOW	SHEET 1 OF 1
				SCALE
				1:3
A	94.02.09	NEW ISSUE		
B	99.03.10	UPDATE DIMENSION AND TEMPLATE		
C	06.04.13	UPDATE MATERIAL PER NCR 029		



REFERENCE ONLY

D2214 WINDOW

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) MANUFACTURE FROM TEMPLATE DT8223 (DIMENSIONS ARE FOR REF. ONLY)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

